

Date: Tuesday, 22/04/2008 3:53:13 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, OUTBOARD, RH, 206  
 Job Number : 38750  
 Estimate Number : 10523  
 P.O. Number :  
 This Issue : 22/04/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D26652  
 Drawing Number : D2665 REV. D  
 Project Number : N/A  
 First Issue : / / Type : MACHINED PARTS Drawing Revision : D  
 Material :  
 Previous Run : 37331 Due Date : 10/05/2008 Qty: 12 Um: Each  
 Written By :  
 Checked & Approved By : JLD 08.4.23  
 Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in  
 house process EC  
 Est Rev:D As per Rev D 07-03-19 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 Saddle Billet, 7075



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 2X6.25X7.875

Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length

B 34644

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Program batch number

2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet

3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet

4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet

5- Deburr

P10 →

IP 08/06/10 (11)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

IP 08/06/11 (11)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IP 08/06/11 (11)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

IP 08/06/16 (11)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2665-2 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: DP Date: 08/04/20  
D206-642 QA: N/C Closed: DP Date: 08/06/20

NCR: 38750		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/06/09	2.0.	Raise wrong tools so the saddle was on a angle on the second vise and it open the Bone too big, Saddle #4, #2 and #3 was affected	<u>08.06.13</u> <u>per</u> <u>08/04/20</u>	SCRAP #2, THICKNESS BELOW TOL AT SKID HOLES. SADDLE 3&4 ACCEPTABLE. FIT ON SKID & TUBE OK. THICKNESS IN TOL.	<u>08/06/09</u>	<u>08.06.13</u> <u>per</u> <u>08/04/20</u>	<u>08.06.13</u> <u>per</u> <u>08/04/20</u>	<u>08.06.13</u> <u>per</u> <u>08/04/20</u>

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 3:53:13 PM  
User: Julie Lecpcq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 38750

Part Number: D26652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/06/08

30 min  
16/06/2008  
S.022  
13.46

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107 925

m-l 08/06/08

#1 318.1  
#2 1338750  
#3 D26652  
#4

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-06-16

(XII)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST 436

AS 08/06/17

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/18

Job Completion



u 08.06.17

Dart Aerospace Ltd

W/O:

DATE

## WORK ORDER CHANGES

STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>38750</b>
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b>	<b>D2665-2</b>
<b>Inspection Dwg:</b> D2665 Rev. D		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.114	.116	.117	.120		
B	0.100	0.140		.127	.125	.125	0.123		
C	1.125	1.145		1.134	1.134	1.135	1.153		
D	0.615	0.685		.685	.680	.680	.680		
E	0.240	0.260		.253	.253	.253	0.252		
F	1.313	1.343		1.325	1.325	1.325	1.325		
G	0.210	0.230		.222	.218	.218	.223		
H	0.100	0.180		.132	.130	.130	0.135		
I	2.470	2.510		2.491	2.499	2.500	2.492		
J	1.565	1.585		1.575	1.575	1.594	1.5975		
K	0.235	0.240		.239	.23	0.239	0.239		
L	0.100	0.120		.108	0.	0.110	0.110		
M	0.990	1.010		1.024	0.994	0.994	0.995		
N	0.510	0.515		.510		0.512	0.512		
O	5.990	6.010		5.997	6.001	6.001	6.000		
P	1.245	1.255		1.250	1.249	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.316	0.3155	0.3155	0.3155		
S	0.315	0.322		.319	.320	.320	.320		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.367	1.367	1.367		
V	0.787	0.807		.799	.796	.795	0.797		
W	0.540	0.560		.540	.558	.556	0.551		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.259	.259	.257	.259		
Z	0.912	0.932		.917	.917	.917	0.9145		
AA	0.490	0.510		.501	0.506	0.506	0.506		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject				Reject	Reject	Reject	Reject		

Measured by: <b>LS</b>	Audited by: <b>S</b>
Date: <b>08/06/01</b>	Date: <b>08/06/16</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI.9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38750	
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b> D2665-2	
<b>Inspection Dwg:</b> D2665 Rev. D		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.100	0.140		0.125	0.1195	0.1145	0.115		
B	0.100	0.140		0.131	0.129	0.123	0.120		
C	1.125	1.145		1.1325	1.132	1.127	1.127		
D	0.615	0.685		0.680	0.685	0.680	0.680		
E	0.240	0.260		0.260	0.255	0.256	0.257		
F	1.313	1.343		1.325	1.326	1.322	1.324		
G	0.210	0.230		0.225	0.224	0.2205	0.220		
H	0.100	0.180		0.136	0.136	0.140	0.140		
I	2.470	2.510		2.491	2.498	2.500	2.500		
J	1.565	1.585		1.573	1.572	1.566	1.567		
K	0.235	0.240		0.239	0.239	0.239	0.239		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		0.995	0.995	0.992	0.995		
N	0.510	0.515		0.510	0.510	0.510	0.510		
O	5.990	6.010		6.000	6.000	5.997	6.000		
P	1.245	1.255		1.250	1.249	1.2485	1.250		
Q	2.495	2.505		2.500	2.500	2.4995	2.500		
R	0.313	0.318		0.3155	0.3155	0.315	0.3155		
S	0.315	0.322		0.320	0.327	0.316	0.315		
T	2.495	2.505		2.500	2.498	2.497	2.498		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.797	0.798	0.793	0.796		
W	0.540	0.560		0.549	0.550	0.550	0.5505		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.259	0.260	0.261	0.260		
Z	0.912	0.932		0.920	0.920	0.920	0.918		
AA	0.490	0.510		0.5005	0.502	0.498	0.502		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>SP</i>	Audited by: <i>SP</i>
Date: <i>08/05/10</i>	Date: <i>08/06/10</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	38750
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b>	D2665-2
<b>Inspection Dwg:</b> D2665 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

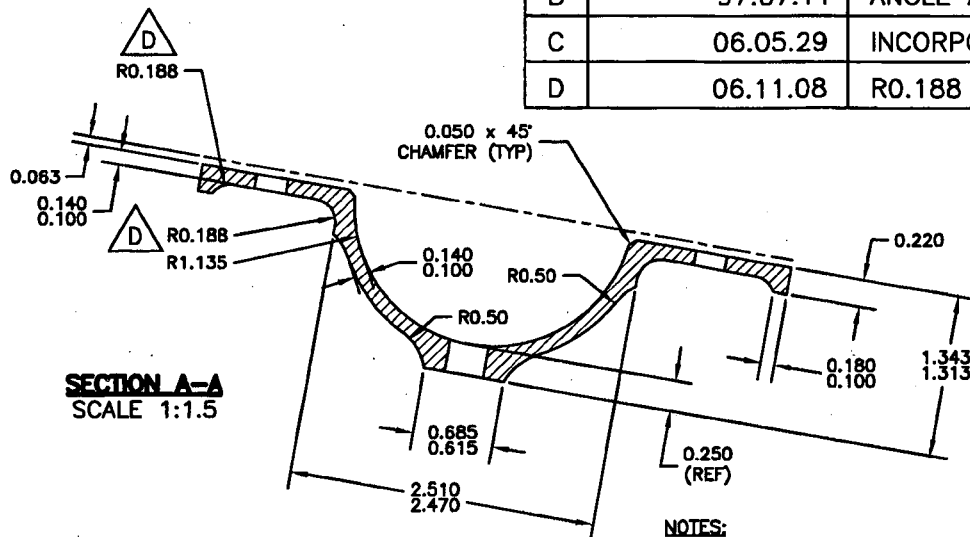
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	0.100	0.140		0.114	0.113	0.114	0.113		
B	0.100	0.140		0.120	0.120	0.120	0.120		
C	1.125	1.145		1.135	1.1305	1.131	1.131		
D	0.615	0.685		0.680	0.680	0.680	0.680		
E	0.240	0.260		0.253	0.252	0.252	0.252		
F	1.313	1.343		1.3235	1.324	1.324	1.325		
G	0.210	0.230		0.220	0.219	0.220	0.220		
H	0.100	0.180		0.140	0.140	0.138	0.139		
I	2.470	2.510		2.500	2.500	2.499	2.500		
J	1.565	1.585		1.571	1.571	1.571	1.570		
K	0.235	0.240		0.239	0.239	0.239	0.239		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		0.995	0.995	0.995	0.995		
N	0.510	0.515		0.510	0.510	0.510	0.510		
O	5.990	6.010		6.000	6.001	6.000	6.000		
P	1.245	1.255		1.249	1.250	1.249	1.248		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.3155	0.3155	0.3155	0.316		
S	0.315	0.322		0.322	0.322	0.322	0.322		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.363	1.362	1.362	1.362		
V	0.787	0.807		0.795	0.795	0.797	0.796		
W	0.540	0.560		0.551	0.5505	0.551	0.552		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.912	0.932		0.919	0.918	0.919	0.919		
AA	0.490	0.510		0.501	0.503	0.502	0.503		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>DDP</u>	Audited by: <u>S</u>
Date: <u>08/06/11</u>	Date: <u>08/06/11</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

**DART**

DESIGN	<i>PH</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>PH</i>	APPROVED	<i>CB</i>	DRAWING NO. D2665
				REV. D SHEET 1 OF 1
DATE	06.11.08	TITLE	SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE		
B	97.07.11	ANGLE AND NOTES ADDED		
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095		
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313		

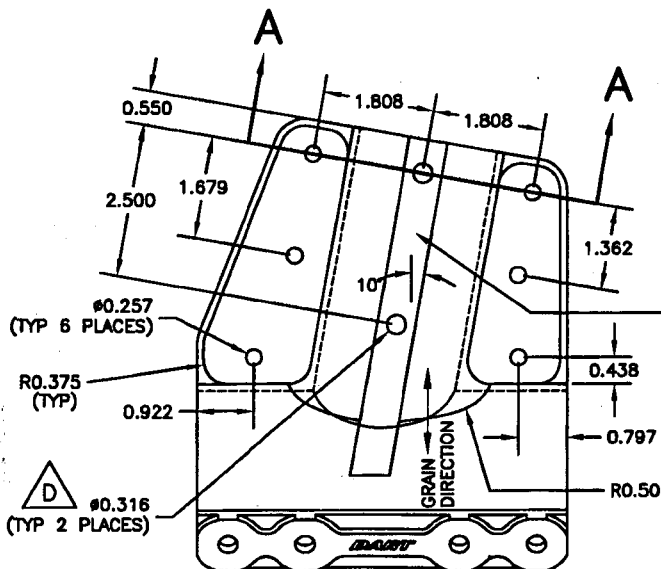


RELEASED

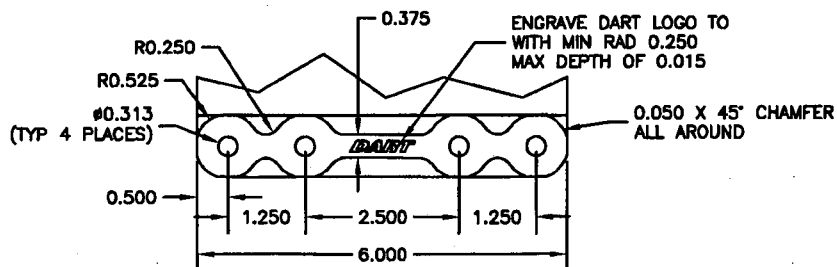
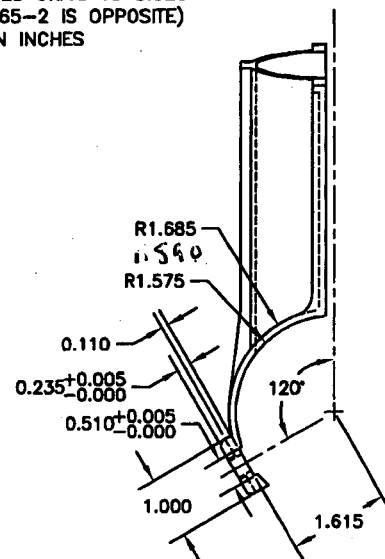
07.02.12

## NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART  
NUMBER AND  
BATCH NUMBER  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RADIUS  
OF 0.010



SHOP COPY  
RETURN TO  
ENGINEERING

D2665-1 SADDLE FWD OUTSIDE HIGH

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 30750

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